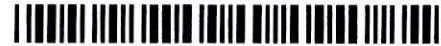




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

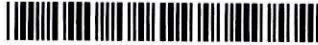
D3208-1
Job Sheet 179693



Part No: D3208-1

Job Qty: 6 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP: B 04.05.25 Material changed for Step 4 KJ/JLM IPP REV B:PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:C 12.04.20 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/04
100	Waterjet	6 pcs	7/18/18	7/18/18	0.00	0.39	Waterjet1		SC 18/07/04
115	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
120	Brake NC	6 pcs	7/18/18	7/18/18	0.03	0.31	Brake NC 2		38
130	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC5		38
140	HandFinish	6 pcs	7/18/18	7/18/18	0.00	0.19	HandFinish1		D.R. 18/08/16
150	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC7-2		AUG 16 2018 38
160	Packaging	6 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1	5025	AUG 20 2018 9-89
170	QC21-SA	6 Ea	7/18/18	7/18/18	0.00	0.00	QC21		AUG 20 2018 9-89

Part Op 100 - 1-Cut as per Dwg
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.9870 sf (.1645 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.098inches + 0.005 - 0.001	0.103 0.097	0,098	
2	Doubler	0.130inches ± 0.030	0.160 0.100	0,130	
3	Doubler	4.060inches ± 0.030	4.090 4.030	4,056	
4	Doubler	5.600inches ± 0.030	5.630 5.570	5,60	
5	Doubler	0.040inches ± 0.010	0.050 0.030	0,040	

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only	
Work Order: _____		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Engineering ☐ Quality ☐ Other ☐	
NCR No. _____		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	
Suspec		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	
DISPOSITION		Skid-tube ☐ Machining ☐ Thermoforming ☐	
Rework ☐ Scrap ☐ Use-as-is ☐			
Step #: _____			
Description Work Order Deviation			
Date: _____			
Completed By _____			
and / Supervisor _____			
QA Coordinator Approval _____			
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com			
Container No: S089820			
Part: D3208-1			
Job No: 179693			
Serial No/Batch: S089820			
Revision: _____			
Inspector: _____			
Exp Date: _____			
Instructions: _____			
Date: 07/07/18			
Root Cause			
Environment		Pressur	
Design		Bendin	
Doc/Data		Centre Not Concentric	
Equip/Tooling		Cracks	
Handling/Pre		Crimp/Kink/Ripple/Wave	
Material		Cuffs	
Internal Transport		Crushing	
Tribal Knowledge		Heat Treat	
LOA		Wave/Twist in Tube	
Substation		Marks/Chatter	
Past Expiry Date			
Misidentified			
OTHER: _____			
Broken/Damage/Defect			
Inspection Incomplete/Unqualified			
Contamination			
Countersink			
Cut Too Short			
Instructions Incomplete/Unclear			
Drill Holes			
Wrong Stock Pulled			
Out of Sequence			
Off-set			
Mislabeled			
Fit/Function			
Misaligned/off center			
Part Lost/Missing			
Part Moved			
Drawing			
Finish			
Misread			
Turning Sequence			
Positioned Wrong			
Outside Dimensions			
Over/Under tolerance			
Part Incorrect			